

dupherte

Page 1

Quality Control

13.8.19

B. & 19

13-07-31/4A

Work Order ID 82856

82856

Page 2

July-25-13 7:42:10 AM

Item ID: D350-588-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Fwd Hinge Modification

Start Date: 4/10/12 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/20/12 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				5	13/8/20		(SAP) 08-28
130	Packaging	0.00							
Packaging	Memo								
	Identify and pack for shipping as per PPP D350-588-011								
	Location: 16 30A Change A11								
	PPP Rev:								
140	QC21- Final Inspection - Work Order Release	0.00							
140	QC	0.00							
Quality Control	Memo								

MC5 13-08-20

MC5 13-08-20

Picklist Print

July-25-13 7:42:08 AM

Page 1

Work Order ID: 82856

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 4/10/12

Required Date: 4/20/12

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:M04.08.31Added D2690-17KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Screw

Purchased

No

120

Each

144.0000

2

10

78

9

Shp 50

Location

Loc Qty

Loc Code

ST346

144

123831

44

M126175

100

123931

AN526C832R8

Screw

Purchased

No

120

Each

192.0000

8

40

70

Shp 50

Location

Loc Qty

Loc Code

ST345

16

122814

8

123522

8

ST516

176

125388

176

125388

AN526C832R9

Screw

Purchased

No

120

Each

333.0000

8

40

20

Shp 50

Location

Loc Qty

Loc Code

ST345

324

M126105

324

ST516

9

125388

9

126105

AN960JD10

WASHER

NAS1149D0363J

Purchased

No

120

Each

0.0000

4

20

20

Shp 50

AN960JD8

Washer

NAS1149DN832J

Purchased

No

120

Each

0.0000

24

120

20

Shp 50

124392

126221

20

20

20

20

20

20

20

20

20

20

20

Picklist Print

July-25-13 7:42:08 AM

Page 2

Work Order ID: 82856

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 4/10/12

Required Date: 4/20/12

Start Qty: 5.00

Required Qty: 5.00

D2143
Hinge Bracket

Manufactured No

120 Each 15.0000

1) 5 - 20

Location

Loc Qty

Loc Code

ST005

15

92166

3

98391

12

3x 92166
2x 98391

D2144
Hinge Doubler

Manufactured No

120 Each 8.0000

1) 5 - 20

Location

Loc Qty

Loc Code

ST005

8

92181

8

92181

D2150
Packer Doubler, Hinge

Manufactured No

120 Each 15.0000

2) 10 - 20

Location

Loc Qty

Loc Code

ST005

15

95890

15

95890

D2151
Packer Doubler

Manufactured No

120 Each 18.0000

2) 10 - 20

Location

Loc Qty

Loc Code

ST005

18

95852

18

95852

D2153
Door Prop

Manufactured No

120 Each 73.0000

1) 5 - 20 13-07-31

Location

Loc Qty

Loc Code

FG

5

85865

5

ST260

68

100934

36

101672

32

101672

July-25-13 7:42:08 AM

Shop Packet Print

Page 2

Picklist Print

July-25-13 7:42:08 AM

Page 3

Work Order ID: 82856

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 4/10/12

Required Date: 4/20/12

Start Qty: 5.00

Required Qty: 5.00

D2154

Bracket, Stud

Manufactured No

120 Each 29.0000

1 5 - 10 - 10

3mb 8

Location

ST005
100839
98950
ST006
82333

Loc Qty

18
12
6
11
11

Loc Code

82333

D2237

Striker Plate

Manufactured No

120 Each 35.0000

2 10 - 20 - S.D.

3mb 8

Location

ST007
93697
96996

Loc Qty

35
10
25

Loc Code

96996

D2461

Seal(per foot)
cut 1 X 87.00"

Manufactured No

120 743.2139

7.25 38.157895 - 10 13-07-30

Guaranteed
8/31/13

SA SH

Location

ST402
102517
ST415
39782
55054
63880
73644
85225

Loc Qty

425.22
425.22
317.993894
6.5
4
14.8237
113.702984
178.96721

Loc Code

102517

Picklist Print

July-25-13 7:42:09 AM

Page 4

Work Order ID: 82856

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 4/10/12

Required Date: 4/20/12

Start Qty: 5.00

Required Qty: 5.00

D2463 Manufactured No
1/2" Seal (Sper foot)
cut 1 X 87.00"

Low seal
5/31/13
Shp
SP

Location

ST403
72232
79478
83542
90297
95774
98335

120 f

543.4882 7.25 38.157895

Loc Qty

543.4881745
15.38
0.43737
0.04291
20.82
54.6278945
452.18

Loc Code

D2583 Manufactured No
Latch Bracket

Shp
SP

Location

ST012
100492
101760
ST020
99036

120 Each

53.0000

Loc Qty

41
15
26
12
12

Loc Code

D2585 Manufactured No
Latch Clamp

Shp
SP

Location

ST012
100527
101805
99063

120 Each

56.0000

Loc Qty

56
26
25
5

Loc Code

98335
2 *10* *20*

99036
2 *10* *13-07-30*

6+100527
4x 99063

July-25-13 7:42:09 AM

Shop Packet Print

Page 4

Picklist Print

July-25-13 7:42:09 AM

Page 5

Work Order ID: 82856

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 4/10/12

Required Date: 4/20/12

Start Qty: 5.00

Required Qty: 5.00

D2586
Door Latch

Manufactured No

120 Each 112.0000

2 10 *JP*

Shp

Location

Loc Qty

Loc Code

FG
83893
95760

11
10
1

return2013

3

xxxxx

3

ST203A

98

100607

98

100607

Manufactured No

120 Each 7.0000

5 *JP*

D2587
Door Plug

Shp

Location

Loc Qty

Loc Code

ST012
100426

7
7

100426

Manufactured No

120 Each 73.0000

5 *JP*

D2589
Keys, Key Chain

Shp

Location

Loc Qty

Loc Code

ST012
58194

73
73

58194

Manufactured No

120 Each 29.0000

5 *JP* *13-07-30*

D2690-17
Cable

Shp

Location

Loc Qty

Loc Code

ST016
100261
100752
102311
91824
94470
95699

29
2
10
4
4
4
5

95699

July-25-13 7:42:09 AM

Shop Packet Print

Page 5

Picklist Print

July-25-13 7:42:09 AM

Page 6

Work Order ID: 82856

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 4/10/12

Required Date: 4/20/12

Start Qty: 5.00

Required Qty: 5.00

~~D2857-1~~
Hinge Bracket

Manufactured No

120 Each 32.0000

Location

Loc Qty

Loc Code

FG
82261
91914
ST019
100965
91914
95859

5
4
1
27
24
1
2

2x 100965

3x 91914

~~D2857-2~~
Hinge Bracket

Manufactured No

120 Each 37.0000

Location

Loc Qty

Loc Code

FG
78904
ST019
100769
95712

3
3
34
24
10

95712

~~D2858-1~~
Hinge Bracket

Manufactured No

120 Each 36.0000

Location

Loc Qty

Loc Code

FG
77019
ST019
100756
82337
95701

2
2
34
12
1
21

2x 95701

July-25-13 7:42:10 AM

Shop Packet Print

Page 6

Picklist Print

July-25-13 7:42:10 AM

Page 7

Work Order ID: 82856

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 4/10/12

Required Date: 4/20/12

Start Qty: 5.00

Required Qty: 5.00

D2858-2

Hinge Bracket

Manufactured No

120 Each 26.0000

5 - 20 20

Location

Loc Qty

Loc Code

FG
77020
ST020
89263
95851

2
2
24
3
21

3x 89263
2x 95851

FG-778150-550-ROL

778 1 9oz Glass 50x125yd

1- cut 1 square ft of glass cloth

Purchased No

120 sf 779.1600

5 - 20 20

Location

Loc Qty

Loc Code

CA
123239

779.16
779.16

123239

MS20426AD3-4

RIVET

Purchased No

120 Each 17,978.000

12 60 - 20 20

Location

Loc Qty

Loc Code

ST334
123164
ST505
104374
123021
124814

1834
1834
8024
12
12
8000

123164

ST509
124586
125578

8120
120
8000

MS20470AD4-5

RIVET, UNIVERSAL HEAD

Purchased No

120 Each 1,583.0000

18 90 - 20 13-07-30

Location

Loc Qty

Loc Code

GA
122452
ST336
122452
125654

218
218
1365
584
781

125654

July-25-13 7:42:10 AM

Shop Packet Print

Page 7

Picklist Print

July-25-13 7:42:10 AM

Page 8

Work Order ID: 82856

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 4/10/12

Required Date: 4/20/12

Start Qty: 5.00

Required Qty: 5.00

MS21042L08

Purchased

No

120

Each

3,397.0000

18

90

JB

80

Nut

JMS SX

Location

Loc Qty

Loc Code

ST315

1397

122141

3

122452

9

122814

500

123900

885

ST505

2000

123900

125445

2000

MS21042L3

Purchased

No

120

Each

7,744.0000

20

JB 13-07-30

Nut

JMS SX

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

235

111668

1

117885

32

119017

55

119075

138

123265

43

M126036

966

ST506

1488

126036

123900

912

124291

576

ST510a

5000

M126275

1000

M126333

4000

July-25-13 7:42:10 AM

Shop Packet Print

Page 8

Picklist Print

July-25-13 7:42:10 AM

Page 9

Work Order ID: 82856

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

MS27039-08-11

SCREW

Purchased No

Start Date: 4/10/12 Required Date: 4/20/12
Start Qty: 5.00 Required Qty: 5.00

120 Each 956.0000

2

10

-23



Shas

Location

ST307

122441

123352

123900

ST308

125654

Loc Qty

660

100

500

60

296

296

Loc Code

125654

120 Each 872.0000

2

10

-23

12-07-30



MS27039-1-15

Screw

Purchased No

Location

ST506

124326

Loc Qty

872

872

Loc Code

124326

Shas

July-25-13 7:42:10 AM

Shop Packet Print

Page 9

REFERENCE ONLY

SM

3.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041 •	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-101	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9-oz. GLASS CLOTH (S-CLASS)

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Revision: D

Date: 02.01.17

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